

Date: Monday, 6/12/2006 3:25:36 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CAP  
Job Number : 27488  
Estimate Number : 10519  
P.O. Number : N/A  
This Issue : 6/12/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : PURCHASED PARTS  
Previous Run : 26351  
Written By :  
Checked & Approved By :  
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC

Part Number : D2855  
Drawing Number : D2855 REV. A  
Project Number : N/A  
Drawing Revision : A  
Material : N/A  
Due Date : 6/30/2006 Qty: 25 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1490

Cast per Dwg D2855

Material Release Note Required

C206115104 (25) 100

2.0 D2855P Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)  
CAP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

AR 06/08/14 (99)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-08-15 (99)  
QSPOR

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

SB 06/08/23 99

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06-08-23*

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



*M102391*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FL/YL 07/01/24 (99)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*G.M 07/01/24 (99)*

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 50.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 ALS7-1032-225 Insert

or AKS7-1032-225

or ALS4-1032-225 ✓

or AKS4-1032-225

*19393*

*YL 07/01/25*

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

*YL 07/01/25 x 99*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*FL 07 01 25 (99)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP4*

*FL 07 01 25 (99)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 07/01/25

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:25:37 PM  
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## Process Sheet

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Drawing Name: CAP

Job Number: 27488

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



99

Comment: DOCUMENT CONTROL  
Inspection Level 21

27/01/25

Job Completion



U 27.01.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

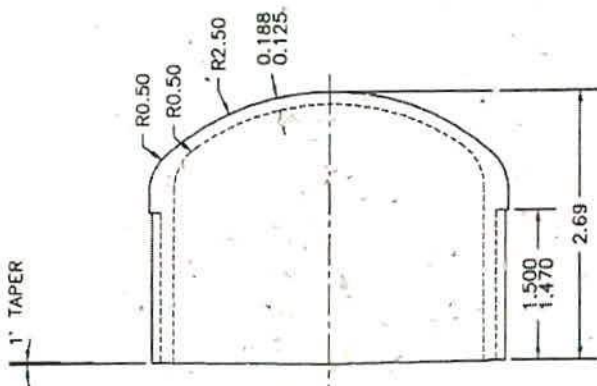
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



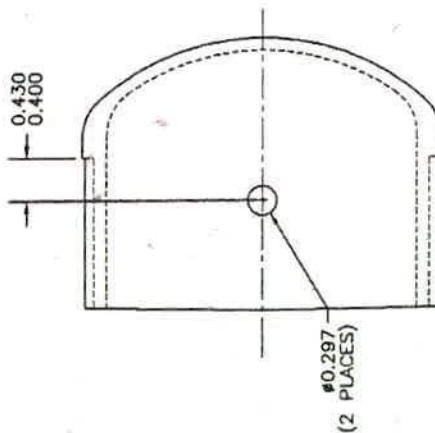
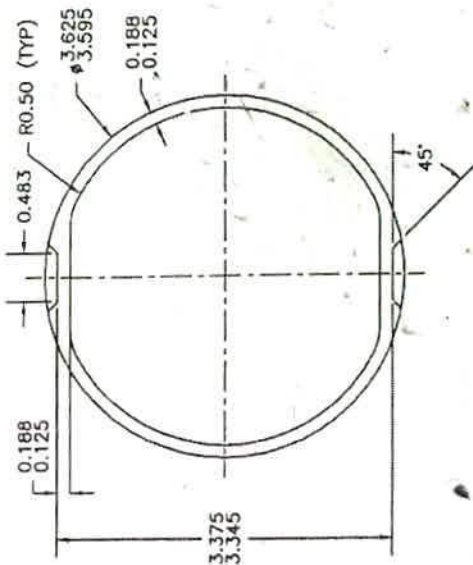


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2855	REV. A SHEET 1 OF 1
DATE 98.12.12	TITLE CAP	SCALE NTS	
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

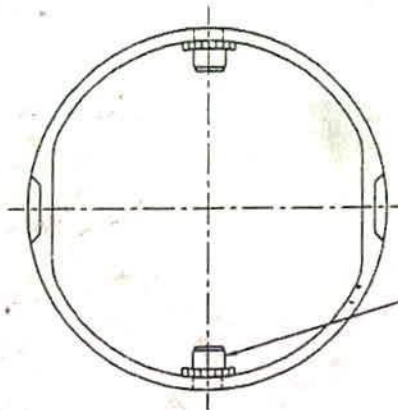
RELEASED  
98.12.14 DS



D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27488

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD714-718 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448Expédié à  
Shipped

DART AEROSPACE

A.F. &amp; P.W.Série no./Serial no.

1270 Aberdeen Street

Packing  
Date: 14/08/2006 Slip No. 6111

Hawksbury, ON, K6A 1K7

Vôtre No. Commande 1490  
Your order No.

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Notes d'autorisation Incoming Release note
100	DRWG D 2855 rev A	Z098046	A356.2	B#0619301 Ingot #815076

Analyse  
Analysis (as in ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne  
Yield :Résistance à la tension :  
Tensile Strength :Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :  
Par/Per :

Coc-100